

Date: Monday, 11/21/2005 11:55:18 AM  
User: Linda Lacelle

## Process Sheet

SLPITE 2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RADIUS BLOCK
Job Number	: 24872		
Estimate Number	: 10822		
P.O. Number	: N/A	Part Number	: D2274
This Issue	: 11/21/2005 S.O. No. : N/A	Drawing Number	: D2274 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: N/A	Material	: N/A
Written By	: See comment below	Due Date	: 12/15/2005 Qty: 500 Um: Each
Checked & Approved By	: See comment below		
Comment	: Est. H 00.05.18 Added inspection level 8 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00125	6061-T6 Bar .75" x .125"
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Comment: Qty.: 0.0962 f(s)/Unit Total : 48.0900 f(s)

6061-T6 Bar .75" x .125"

Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" Bar Batch 117599

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2274

En 05/12/06 539

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 05/12/06 539

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 05/12/06 539

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

DL 05/12/12 472



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RADIUS BLOCK

Job Number: 24872

Part Number: D2274

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

DL 05/12/14 472

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MI 05/12/14 472

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 35

10/5/12/14 472

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 05/12/15 (472)

Job Completion



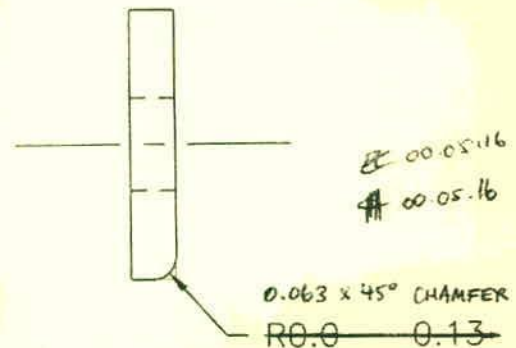
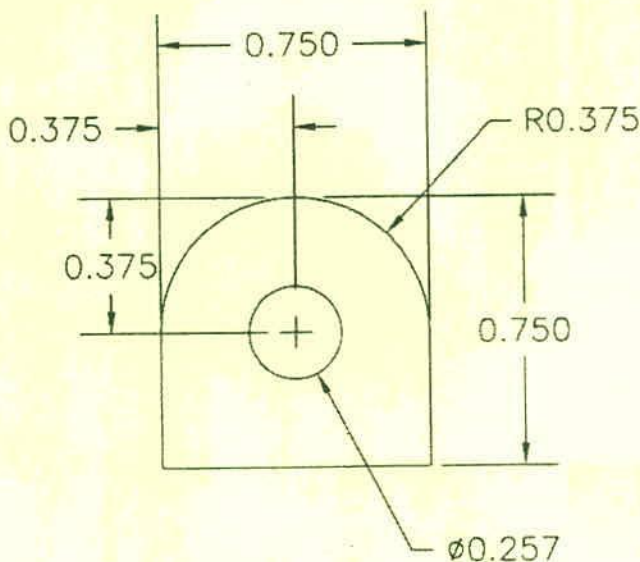
AP 05/12/14





**DART****RELEASED**  
98/08/19 KE

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	



MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK  
OR 6061-T6 (QQ-A-250/11) 0.125 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED







